

Work Order ID 85846

85846

Page 1

June-13-12 1:37:15 PM

Item ID: D3806-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bar

Start Date: 15/06/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 29/06/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/06/15 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3806

B

100

0.00

100

Cold Saw

Hyd Mech

Memo

Cut blanks at 49.70"

0.00

SL 12-06-19

6

110

0.00

110

HAAS 1

HAAS CNC vertical machine #1

Memo

1-Mill as per folio EB070 & dwg

FOLIO REV:

DWG REV:

2-Deburr as required

0.00

12-06-23 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

12-06-23 (x6)

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

12/06/25 6

140

Identify as per dwg & Stock Location: W/E

0.00

140

Packaging

Memo

0.00

Packaging

(x6) 12-06-26

135 WA.

145 QCA

12-06-26

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Start Date: 15/06/2012 Start Qty: 6.00

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Required Date: 29/06/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

12/6/27

120626

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NOTE: Date & initial all entries

Picklist Print

June-15-12 1:37:19 PM

Page 1

Work Order ID: 85846

85846

Parent Item: D3806-3

D3806-3

Parent Item Name: Bar

Start Date: 15/06/2012

Required Date: 29/06/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-07-21 new issue DD verified by:cc
 IPP Rev:B 08-09-23 redesign DD verified by:EC
 11.10.04 rev.b as per dwg DD verified by:EC

IPP Rev:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500		Purchased	No				f	735.9840		25.8			

M304B0 250x0 500

**

SL 12-06-19

304 BAR .250 x .500

Location

Loc Qty

Loc Code

MAT050

735.984

121216

142.08

121547

89.904

122008

504

26

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NOTE: Date & initial all entries

8

7

6

5

4

3

2

1

D

D

D3806-1 BARD3806-5 BAR

C

C

D3806-3 BARD3806-7 BAR

B

B

RELEASED
2011-10-03
MD

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 85846 MLCJ

12/06/15

B	REVISED D3806-1/-3 TO EASE MANUFACTURABILITY; 4.0 WAS 4.00; CHANGED MATERIAL STOCK FOR D3806-1/-3/-5/-7 PER PAR11-106	MB	11.09.29
A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3806	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BAR	NTS
DATE	11.09.29	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8

7

6

5

4

3

2

1

A

A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

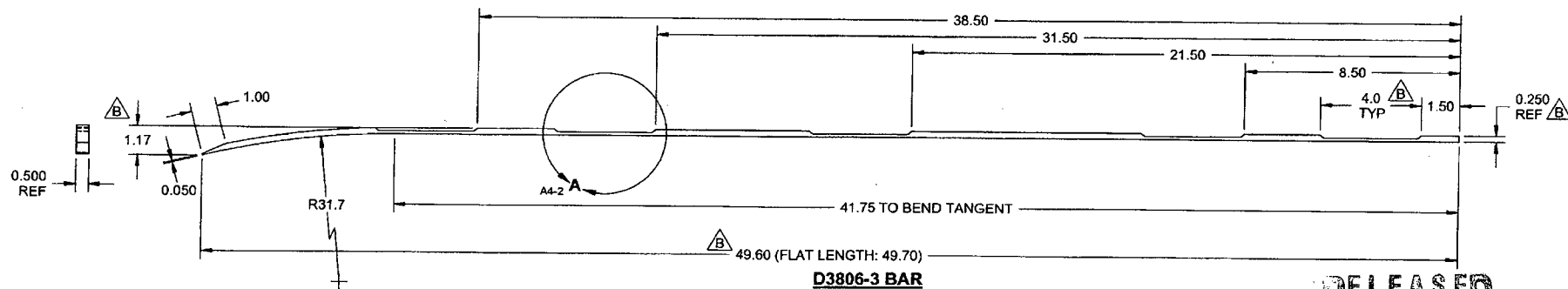
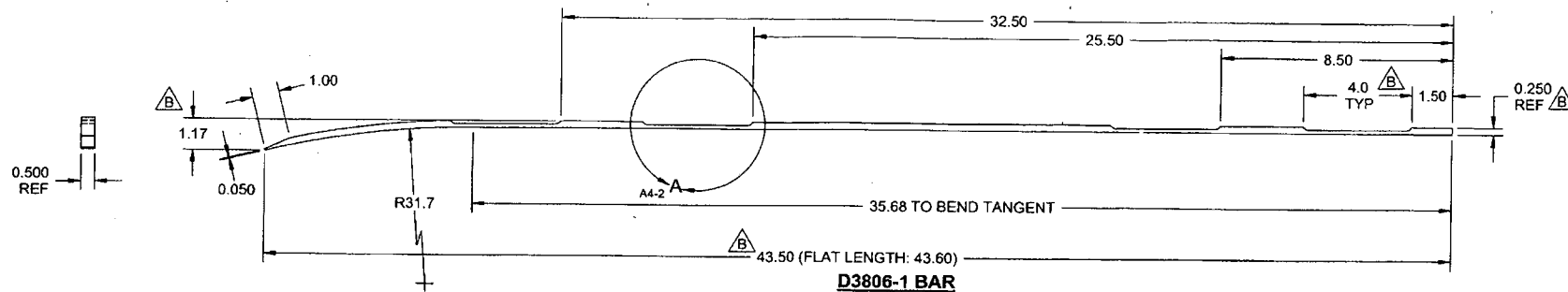
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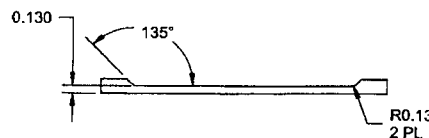
NOTE: Date & initial all entries

05046



RELEASED
2011-10-03

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.250 X 0.500 THICK
REF. DART SPEC. M304B0.250W00.500
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT:
D3806-1 = 1.27 lbs
D3806-3 = 1.42 lbs



DETAIL A
TYP, SCALE 2X

DESIGN	97	DART AEROSPACE USA, INC.
DRAWN	JP	KENT, WA
CHECKED	JP	DRAWING NO. D3806
MFG. APPR.	JP	REV. B
APPROVED	JP	SHEET 2 OF 3
DE APPR.	JP	SCALE
DATE	11.09.29	TITLE BAR
		NTS

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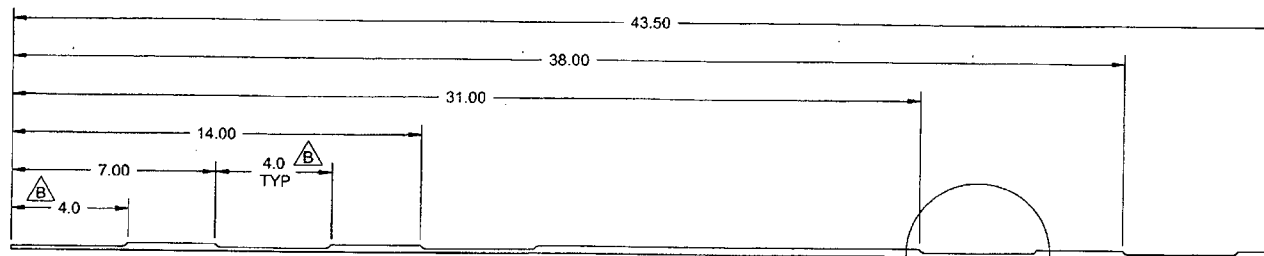
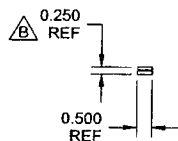
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

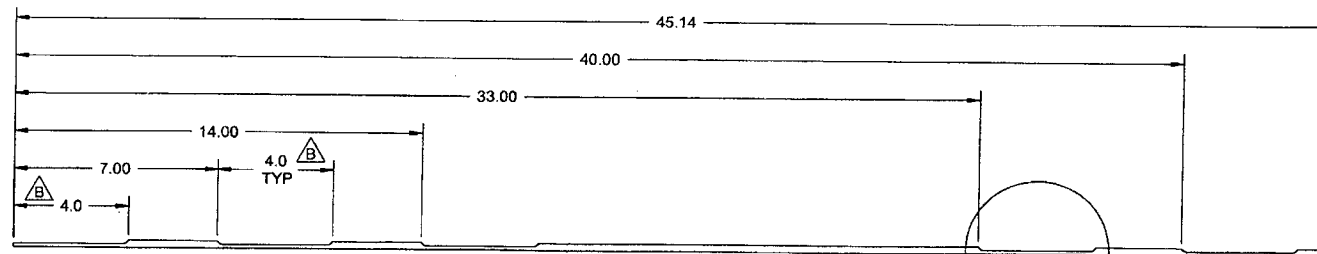
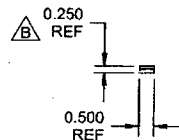
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D3806-5 BAR



D3806-7 BAR

RELEASED
2011-10-03

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.250 X 0.500 THICK
REF. DART SPEC. M304B0.250W00.500
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT:
D3806-5 = 1.22 lbs
D3806-7 = 1.28 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3806	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BAR	NTS
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